

Work Order ID 59792

Friday, June 11, 2010 12:05:33 PM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Item Name: 206 (24") Bearpaw

Stop



Start Date: 6/10/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date:

10-6-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

F3

B10-6-14

(8)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

amf / S.F. 10/06/26

8 0

(PTO)

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

S.F. 10/06/26

8 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D 2432 PAR #: _____ Fault Category: machining NCR: Yes No DQA: _____ Date: 10/07/05
 Resolution: Accepted Disposition: use as is QA: N/C Closed: _____ Date: 10/07/09

NCR: <u>59792</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/26	130	3 bearing pawls are affected by chatter over tolerance by .075" over tolerance R.C. During machining and will lift the part off the two way tape. R.C. Process.	GP 10.06.28 Q51042	Acceptable.	L.F. 10/06/26	DIT 10/06/28	GP 10.06.28 Q51042	S 10/06/30
			GP 10.06.28				GP 10.06.28	S 10/06/30

NOTE: Date & initial all entries

Work Order ID 59792

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Item ID: D2432

Accept

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 6/10/2010 Start Qty: 8.00

Required Date: 6/25/2010 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DTP 10/06/28

8 0

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PP 58477

10-6-29 S/P (4)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29 HJ

W 10/06/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 59792

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Comments:

Start Date: 6/10/2010

Required Date: 6/25/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	279.1000	3.7	29.6			
												1810-6-14	

Location

Loc Qty

Loc Code

MAT

279.1

112186

20.7

113903

88

114624

170.4

114624

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	58792
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓			
B	5.500	+/-0.030	5.506	✓			
C	0.200	+/-0.030	.190	✓			
D	0.25 x 45°	+/-0.030	.250	✓			
E	R0.250	+/-0.030	.250	✓			
F	0.250	+/-0.010	.245	✓			
G	0.625	+/-0.030	.635	✓			
H	0.375	+/-0.010	.377	✓			
I	0.950	+0.030/0.010	.945	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.130	✓			
L	3.28	+/-0.030	3.292	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.928	✓			
O	0.30	+0.030/-0.000	.310	✓			
P	23.750	+/-0.030	23.75	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.25	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.022	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.375	✓			

Measured by:	SP
Date:	10/06/26

Audited by:	DTF
Date:	10/06/28

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

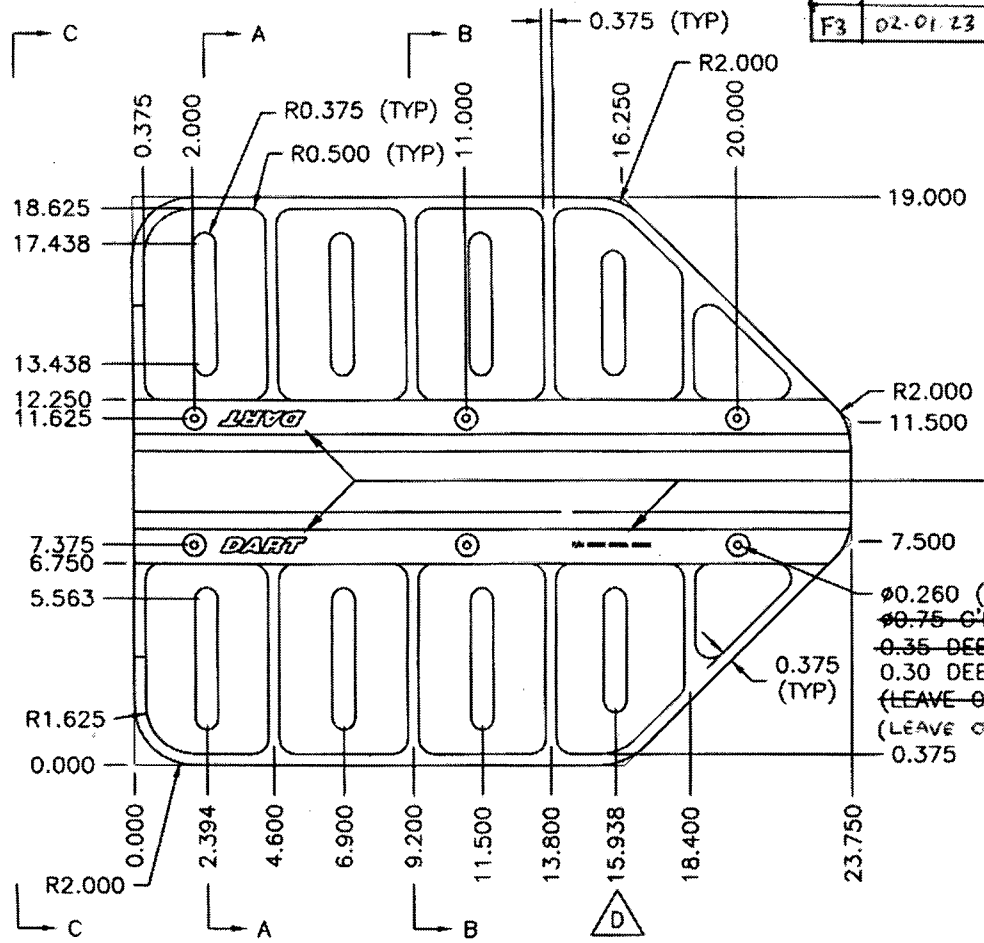
F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

RELEASED
98.06.12 KE

SHOP COPY
RETURN TO
DART
UNCLASIFIED COPY
SUBMITTAL
IT NUMBER
ORDER
NO 59792
B80-64



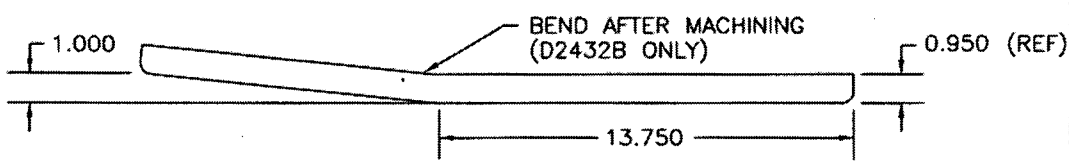
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375

F2
F1
F
F1

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

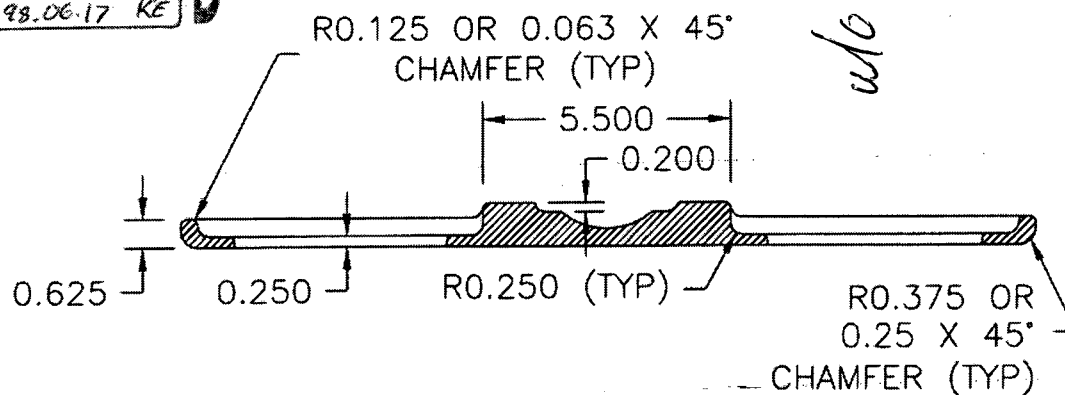
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM		D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

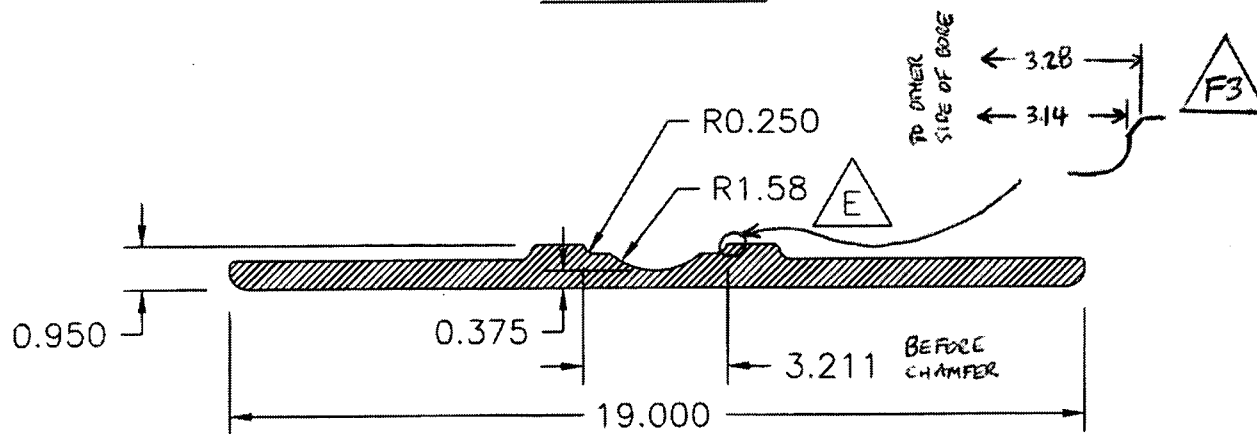


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

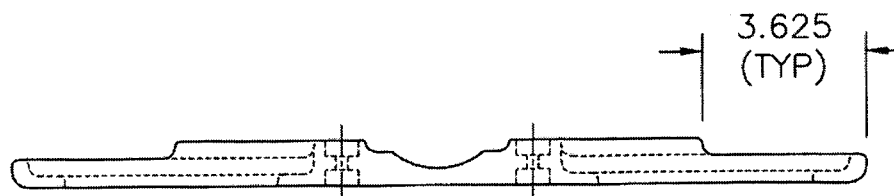
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C